

Work Order ID 80222

February-14-12 4:17:57 PM

80222

Page 1

Item ID: D3407-3

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Stem

Start Date: 14/02/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 28/02/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: M.C.S

Date: 12/02/14

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3407 | Rev E |

100

0.00

100

DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA597 Rev: B & Dwg D3407 Rev: B 2-Deburr

40 ✓

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

✓ 12/2/24

40 ✓

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

✓ 12-02-28

✓

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 80222

February-14-12 4:17:57 PM

80222

Page 2

Item ID: D3407-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Stem
 Start Date: 14/02/2012 Start Qty: 40.00 *40* Cust Item ID:
 Required Date: 28/02/2012 Req'd Qty: 40.00 *40* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | Identify as per dwg & Stock Location: <u>ST WA</u> | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

(40X) SP/2-02-29

MLJ 12/02/29

MLJ 12/02/29
 (40)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

February-14-12 4:18:02 PM

Page 1

Work Order ID: 80222

80222

Parent Item: D3407-3

D3407-3

Parent Item Name: Stem

Start Date: 14/02/2012

Required Date: 28/02/2012

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP Rev:A05.10.18New issueKJ/EC

IPP Rev:B Now on Doosan 08-05-14 JLM Verified By:DD

IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M174R0.750

Purchased

No

100

f

21.8240

0.366

15.41053

M174R0 750

17-4 round bar .750

**

12/2/24

Location

MAT030

Loc Qty

21.824

Loc Code

117683

0.465

118483

0.359

120196

21

16 L+

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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|-----------------------|--------|--------------|---------|
| DART AEROSPACE LTD | | Work Order: | 80222 |
| Description: Stem | | Part Number: | D3407-3 |
| Inspection Dwg: D3407 | Rev: E | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|----------------------------|------------------|--------|--------|----------------------|----------|
| 0.063 | +/-0.010 | 0.063 | / | | SI-P | Vern |
| 1/4-28 UNF | Max: 0.2668 Min: 0.2635 | 0.265 | / | | SI-G | Mic |
| Major Ø | Max: 0.249 Min: 0.2425 | 0.245 | / | | | |
| Ø0.625 | +/-0.010 | 0.625 | / | | | |
| Ø0.363 | +/-0.010 | 0.360 | / | | | |
| Ø0.750 | +/-0.010 | 0.750 | / | | | |
| R0.100 | +/-0.010 | R.100 | / | | R.G. | |
| 0.470 | +/-0.010 | 0.470 | / | | | |
| 0.250 | +/-0.010 | 0.254 | / | | | |
| 2.555 | +/-0.010 | 2.550 | / | | | |
| 3.305 | +0.000/-0.010 | 3.299 | / | | | |
| 4.325 | +/-0.010 | 4.327 | / | | | |
| 0.150 | +/-0.010 | 0.154 | / | | | |
| 0.550 | +/-0.010 | 0.557 | / | | | |
| 0.625 | +/-0.010 | 0.622 | / | | | |
| 0.250 | +0.010/-0.000 | 0.260 | / | | | |
| | | | | | | |
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| | | | |
|---------------|----------------|---------------------|-----|
| Measured by: | Audited by: | Prototype Approval: | N/A |
| Date: 12/9/24 | Date: 12-12-28 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------------|------------|----------|
| A | 06.11.08 | New Issue | KJ/JLM | |
| B | 07.09.26 | Tolerances revised | KJ/EC | |
| C | 08.05.14 | Dimensions updated per Dwg Rev D | KJ/JLM | |
| D | 08.10.07 | Dimensions updated per Dwg Rev E | KJ/DD | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

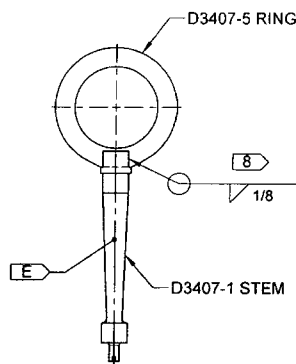
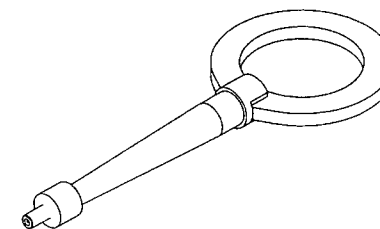
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

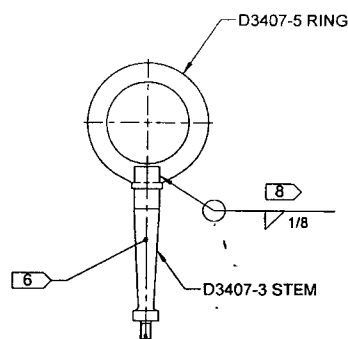
| QTY -041 | QTY -043 | QTY -045 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|-------------|
| X | | | D3407-041 | TOW RING |
| | X | | D3407-043 | TOW RING |
| | | X | D3407-045 | TOW RING |
| 1 | | | D3407-1 | STEM |
| | 1 | | D3407-3 | STEM |
| 1 | 1 | 1 | D3407-5 | RING |
| | | 1 | D3407-7 | STEM |

STOCK BY
REF
ENCLOSURE
UNCONTROLLED COPY
SUBJECT
DATE

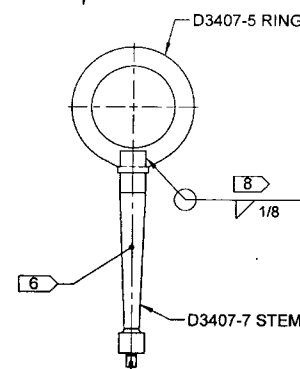
NO. 80222-M.C.S
12/02/04



D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING

RELEASED

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
 - 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

| | | | |
|------------|---|---|--------------|
| E | ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 5 TO ADD IDENTIFICATION (ZN A9-1); REASON: PRODUCTION FACILITY | PH | 08.07.23 |
| D | D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY | PH | 08.04.07 |
| C | -1/3 LONGER FOR FIT W/WASHER | CP | 05.09.09 |
| B | UPDATE DIAMETER, THREAD CLASS ADDED | CP | 05.06.17 |
| A | NEW ISSUE | CP | 05.03.16 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| DRAWN | | | |
| CHECKED | | DRAWING NO. | REV. E |
| MFG. APPR. | | D3407 | SHEET 1 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | TOW RING | NTS |
| DATE | 08.07.23 | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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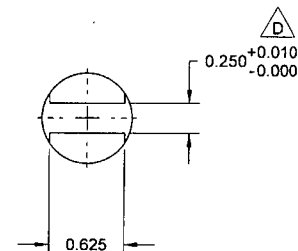
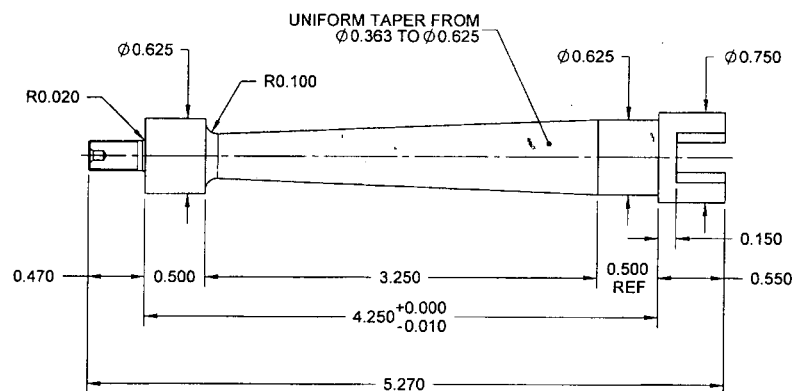
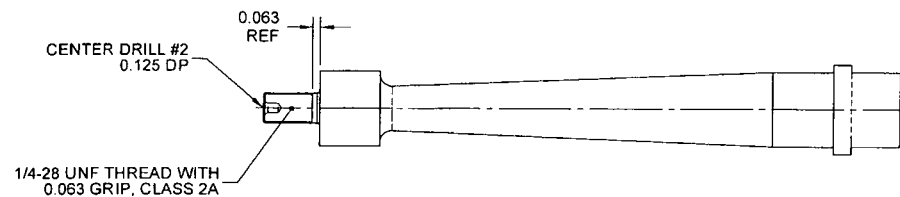
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

80772

**D3407-1 STEM****RELEASED****NOTES:**

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

| | | | |
|------------|----------|---|--------------|
| DESIGN | | DART AEROSPACE USA, INC. | |
| DRAWN | | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. E |
| MFG. APPR. | | D3407 | SHEET 2 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | TOW RING | NTS |
| DATE | 08.07.23 | <small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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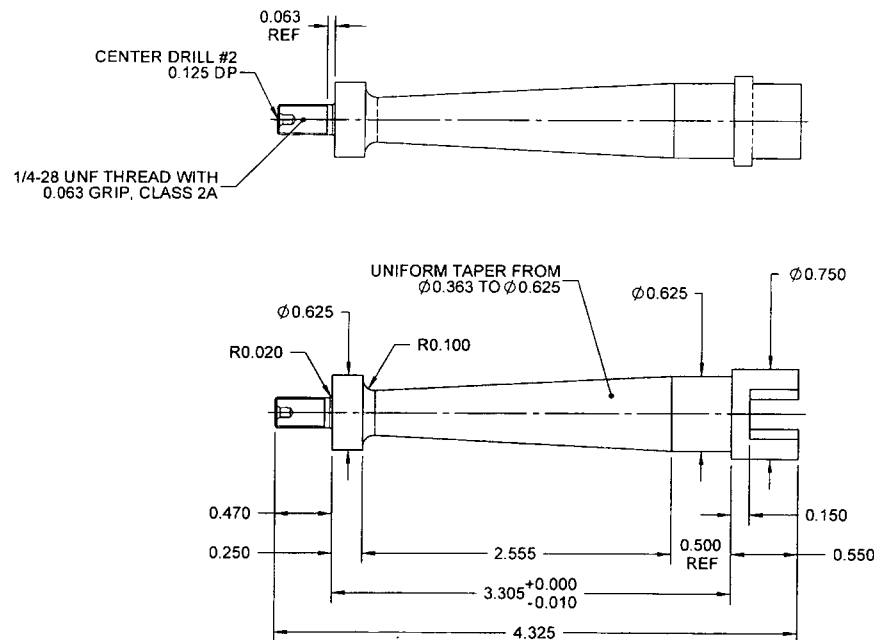
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

80222



D3407-3 STEM

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

| | | | |
|------------|----------|---|--------------|
| DESIGN | 90 | DART AEROSPACE USA, INC. | |
| DRAWN | 1/24 | PORT HADLOCK, WA | |
| CHECKED | 5 | DRAWING NO. | REV. E |
| MFG. APPR. | 5 | D3407 | SHEET 3 OF 5 |
| APPROVED | 5 | TITLE | SCALE |
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RELEASED

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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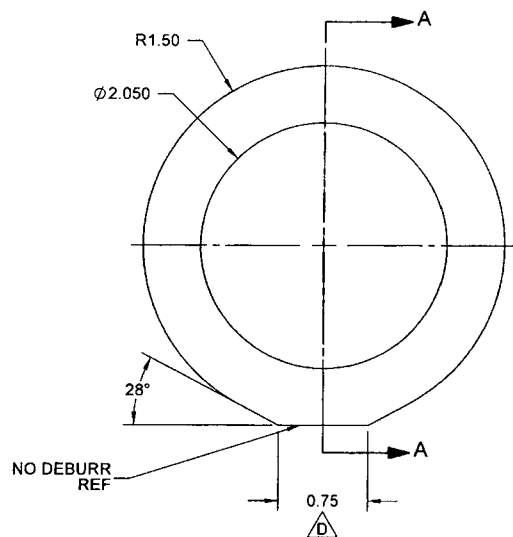
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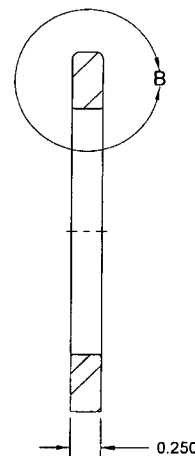
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NOTE: Date & initial all entries

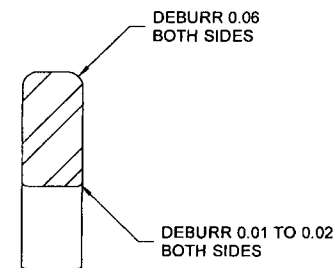
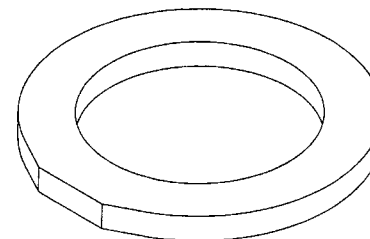
80222



D3407-5 RING



SECTION A-A



**DETAIL B
SCALE 2X**

RELEASED
08-06-0111

- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

| | | | |
|------------|----------|---|--------------|
| DESIGN | 92 | DART AEROSPACE USA, INC. | |
| DRAWN | PER | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. E |
| MFG. APPR. | | D3407 | SHEET 4 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | TOW RING | NTS |
| DATE | 08.07.23 | <small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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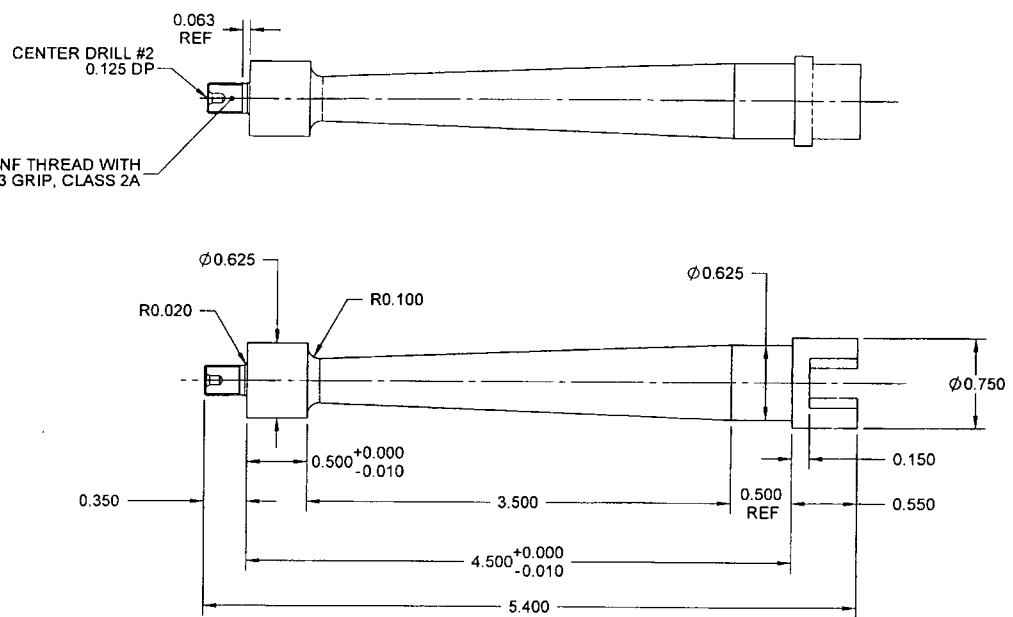
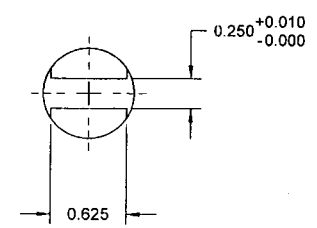
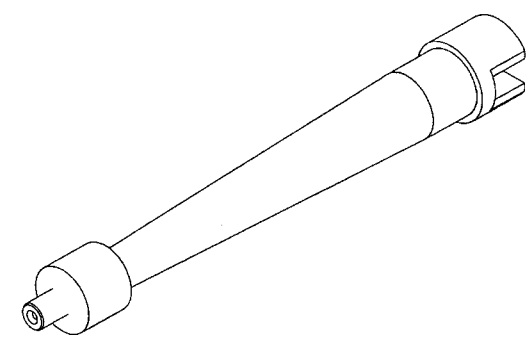
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NOTE: Date & initial all entries

80222



 **D3407-7 STEM**

RELEASED
86-01-100

- NOTES:**
 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 01# UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.34 lbs

| | | | |
|---------------|--------------------|---|--------------|
| DESIGN | AJS | DART AEROSPACE USA, INC. | |
| DRAWN | <i>[Signature]</i> | PORT HADLOCK, WA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. E |
| MFG. APPR. | <i>[Signature]</i> | D3407 | SHEET 5 OF 5 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | TOW RING | NTS |
| DATE 08.07.23 | | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries